

Work Order ID 62209

Page 1

Wednesday, September 22, 2010 11:45:10 A

Item ID: D3537-1

Accept



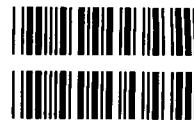
Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 9/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

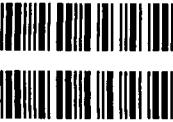
Process Plan:



Date: 10-9-22 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3537	Rev C							

100



FLOW WATER JET

Waterjet

Memo

0.00

IB 10-9-28

FLOW CNC Waterjet

304 . 063

1-Cut as per Dwg D3537 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr
if necessary

(44)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

IB 10-9-28

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

S 10/08/29

Count to

QC

Quality Control

Memo

0.00

(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62209

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Page 2

Item ID: D3537-1

Revision ID:

Item Name: Wearpad

Start Date: 9/22/2010 Start Qty: 40.00

Required Date: 9/29/2010 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Setup Start



Stop



Cust Item ID:

Customer:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.□2-
Identify as D3537-1

44

SB 10/09/20

140



Large Fab

0.00

R 10-10-20 (x44)

Large Fab

Memo

0.00

Large Fab

Qty Description Batch□A/R 2059B Hardcoat
M15450 □1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any
weld that penetrated through Wearpad if necessary

150



QC10- Inspect visual per QSJ004- ground welds

0.00

QC

Memo

0.00

Quality Control

44 10/10/20

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Page 3

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Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 9/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC5- Inspect part completeness to step on W/O

0.00

44

Aureo

QC

Quality Control

170



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

BL 10-10-22

44

Powdercoat

Powder Coating

M112588

Memo

0.00

START TIME:

8:55

OVEN TEMPERATURE:

3200

8:25

FINISH TIME:

180



QC3- Inspect Part Finish

0.00

= 10/10/22

44 0

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Stop



Start Date: 9/22/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

FP-17

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/10/22

Memo

0.00

JMF
10-10-22

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 22, 2010 11:45:14 AM

Page 1

Work Order ID: 62209



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	160.8400	0.106	4.463158	4.7 1810-9-28		

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	146.7	
111323	0	
115688	146.7	115688
MAT20	14.14	
115440	14.14	

(44)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62209
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 10-9-29	Date: 10/08/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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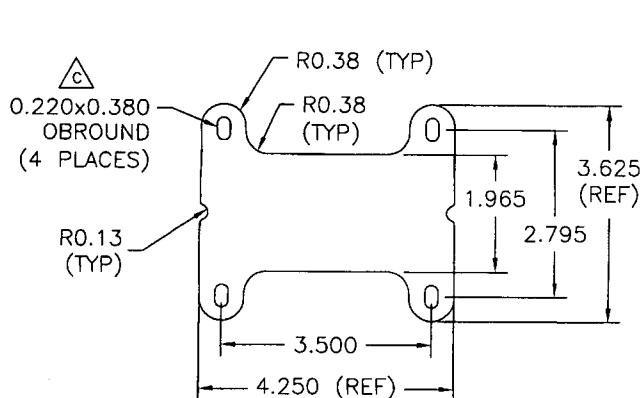
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

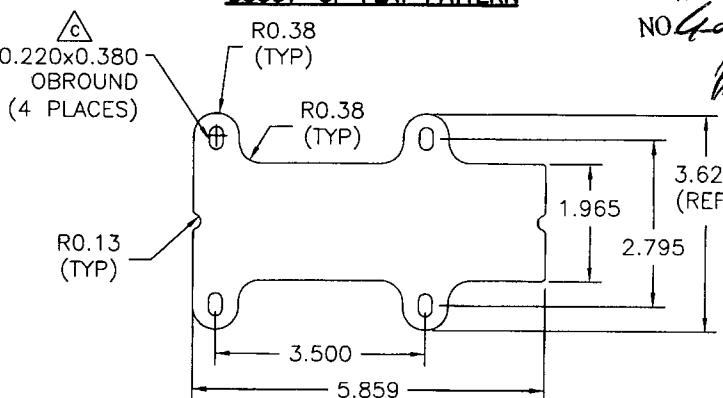
NO 42209

2810-22

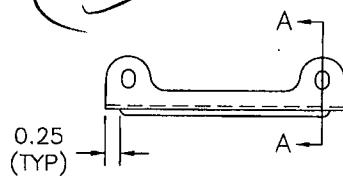
D3537-1F FLAT PATTERN



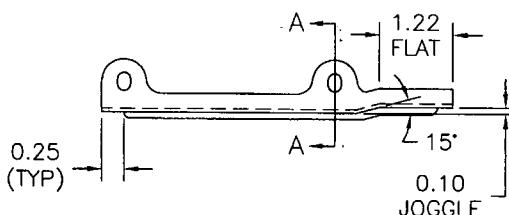
D3537-3F FLAT PATTERN



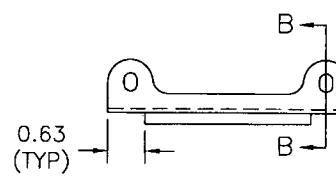
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

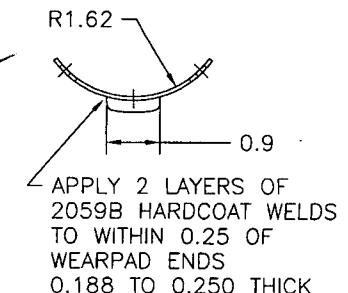
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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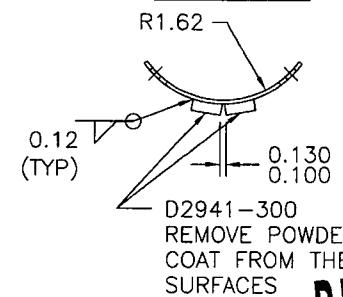
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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH	
CHECKED	APPROVED	DRAWING NO. D3537
DATE	TITLE	REV. C SHEET 1 OF 1 SCALE 1:2
07.04.13	WEARPAD	

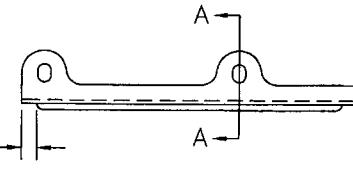
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



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